

ABSTRACT

A main frames having bottom and top frame parts for concrete molding machines of the kind which are used in making slabs or blocks for covering surfaces and erecting walls are usually made by welding together cut standard steel sections of the types HEM, RHS, UNP, etc. The requirements to materials and welds at the making of bottom frames of this kind are high due to the fact that welded structures subjected to vibration only has 10-15% of the basic material strength in the welding zones. Thus, the main frame has a bottom frame part (40) formed of two flame cut bottom plates (42, 44) arranged in parallel as an upper plate (42) and a lower plate (44) and forming the basic shape of the bottom, the bottom plates (42, 44) being interconnected by at least two longitudinal plates (46, 48) and a number of transverse plates (50, 52, 54). In this way, substantial savings are achieved as the main frame can be made with fewer or no welds in the critical areas, or with welds of a lower class.